99513

Page 1

April-11-13 7:45:42 AM Item ID: D4092-041 Accept *N900040100* Setup Start **Revision ID:** Item Name: Maintenance Step Assembly Start Date: Start Qty: 6.00 4/10/13 Cust Item ID: Required Date: 4/24/13 Req'd Qty: 6.00 **Customer:** Reference: Run Process Plan: MLJ Date: 13-04-11 Tooling: Approvals: Date: Stop QC: _____ Date: ____ SPC (Y/N): Date: Operation Sequence ID/ Set Up/ Tool ID Tool # Plan Reject Reject Accept Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp Draw Nbr **Revision Nbr** D4092 В 100 Pick Kit 0.00 *100* Packaging 0.00 Memo Packaging 110 0.00 *110* Small Fab 0.00 Memo Small Fab Assemble as per Dwg Torque screws up to 15-25 in- lbs 120 QC5- Inspect part completeness to step on W/O *120* QC Memo Quality Control

									DQA:	Date	::
NCR: Y	es / N	0			WORK ORDER NON-	CON	FORM	MANCE / UPDATE	QA Closed:	Date	
					DISPOSITION			AGAINST I	DEPARTMENT		
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Part N	lo				Rework Scrap Use-as-is	-	ſ	Skid-tube Crosstube Machining Small Fab noforming Finishing		Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo			<u> </u>	Work Order Update]		Large Fab Composite		Supplier	
Root			[Descr	iption of work order update	In	nitial	Action	Sign &		
Cause	Dat	e Step	Qty		or Non-conformance	Chi	ef Eng	Description	Date	Verification	QC Inspector
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		Not Conc	entric to	o/s	BOM/Route	\vdash	Hardwa		Over/Under	-	Temperature/Cure
	Crack			L	Broken/Damaged			on Incomplete	Part Incorre	-	Weld
	Crush	ed/Crimpe	d		Burrs			ions Incomplete/Unclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs			_	Contamination	-	Mainte	}	Part Moved		
	Heat 1				Countersink	\vdash	Mislabe	+	Positioned V	_	-
	Inspe	tion Strip i	n Tube		Cut Too Short	\vdash	Misread	j [Power Loss/	Surge	Other
	Ripple	s in Bend		L	Drill Holes	-	Offset				
	Torqu	e Waves in	Extrusio	n L	Drawing	-		Calibration			
	Turnir	ng Sequenc	e	Γ	Finish		Out of S	Sequence			

Outside Dimensions

Wave/Twist in Tube

Folio

April-11-13 7:45:42 AM

Item ID: Revision ID: Item Name:	D4092-041 Maintenance	Step Assembly		Accept	*N900	040	100) *	Setup Star Stop	IVI	S1* S2*
Start Date: Required Date: Reference:	4/10/13 : 4/24/13	Start Qty: 6.00 Req'd Qty: 6.00	*6* *6*		Cust Item I Customer:	ID:				·	5/
Approvals:		an:	Date:			ate:			Run Star Stop	"IV	R1* R2*
Sequence ID/ Work Center II 130 *120* Packaging Packaging	D	Operation Description Identify as per dwg & St		Set Up/ Run Hours 0.00 90 0.00 75 7576	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*140 *140* QC Quality Control		QC21- Final Inspection -	Work Order Release	0.00					13,	15/1: mr 13	3 2

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1		Cuffs				Contamination		Mainte	enance			Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print

April-11-13 7:45:49 AM

Work Order ID: 99513

99513

Parent Item: D4092-041 *D4092-041*

Parent Item Name: Maintenance Step Assembly

Start Date: 4/10/13

Required Date: 4/24/13

Start Qty: 6.00

Required Qty: 6.00

Comments:

IPP REV:A NEW ISSUE 10-06-01 JLM VERIFIED BY:DD

R	REV:B AS PER E	CN 11-639 JLM \	/ERIFI	ED BY:DD									
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch		Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1		Manufactured	No			100	Each	14.0000	2	12	7/		1
D4092-1 Maintenance Step	•								**	1	[]3)	105	13
	•			Location		Loc	<u>Qty</u>	Loc Code			~	96	
				GA			1				_ \$	996	22
•					77852		1		_		_		
				ST241A			1		_		_		
					74303		1		_		-		
•				ST271A			12				_		
D4093-1					97500	400	12					_ /	/ /
		Manufactured	No			100	Each	1.0000	1.	6 4			//
D4093-1									**		<i>[</i>]-	3/05	13
				Location		Loc	<u>Oty</u>	Loc Code				$\frac{1}{2}$	2/1
				ST201			1				B	1714	دع ک
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D4093-3		Manufactured	No			100	Each	4.0000	1	6 /		/	1
³ *D4093-3*	•								**		// 、	/_	//2
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IPP

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l Work Orac		<u>-</u>				Rework	1		Skid-tube Crosstube			Water Jet	Engineering
Part N	No.			٠		Scrap	1	!	Machining Small Fab	_	Pro	d. Eng. Coor.	Quality
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NCR N	No					Work Order Update]		Large Fab Composite]	Supplier	
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Root						ption of work order update		Initial	Action		Sign &		
Cause		Date	Step	Qty	+	or Non-conformance	Cr	nief Eng	Description		Date	Verification	QC Inspector
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Misread

Out of Calibration

Out of Sequence

Outside Dimensions

Offset

Other

Power Loss/Surge

Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Picklist Print .

April-11-13 7:45:49 AM

Work Order ID: 99513

99513

Parent Item:

D4092-041

D4092-041

Parent Item Name: Maintenance Step Assembly **Start Date:** 4/10/13 Required Date: 4/24/13 Start Qty: 6.00 Required Qty: 6.00 D4093-5 Manufactured 100 Each 8.0000 *D4093-5* ** Location Loc Oty Loc Code ST093 97494 MS24694-S54 No Purchased 100 Each 78.0000 *MS24694-S54* ** Location Loc Qty Loc Code ST303 78 123900 3 124859 75 MS24694-S55 Purchased No 100 Each 93.0000 ** Screw Location Loc Qty Loc Code ST303 93 123758 1 124296 -92 MS24694-S56 Purchased No 100 Each 29.0000 *MS24694-S56* ** **SCREW** Location Loc Qty Loc Code ST303 29 121340 10 124040 19

											DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON-C	O	VFORI	MANCE / UPI	DATE	QA Closed:	 Date	·
													
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Root					Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Descr	ription	Date	Verification	QC Inspector
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	-	Crushed/	'Crimped			Burrs		4 `	ions Incomplete/U	Jnclear -	Part Lost/Mi	ssing	Wrong Stock Pulled
	-	Cuffs	·			Contamination		Mainte	nance		Part Moved		
		Heat Tre	at			Countersink		Mislabe	eled		Positioned V	Vrong	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	1		Power Loss/	Surge	Other
'	-	Ripples in				Drill Holes		Offset		 -	-		
		Torque V	Vaves in 1	Extrusion	,	Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

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Required Date: 4/24/13

M125268

Required Qty: 6.00

Picklist Print

April-11-13 7:45:49.AM

Work Order ID: 99513

Parent Item:

D4092-041

NAS1149D0332.J

Parent Item Name: Maintenance Step Assembly

99513 *D4092-041*

NAS1149D0332J

Purchased

No

100

Each

937.0000

**

Start Date: 4/10/13

12

Start Qty: 6.00

Location Loc Oty ST294 937 122973 95 125044 842 Each

MS21042L3

Washer

Purchased

No

100

4,883.000

Loc Code

12

**

MS21042L3

Nut

Location	Loc Oty	Loc Code
FP001	3	
122141	3	
GA	119	
122452	119	
ST314	268	
117885	32	4
119017	55	
119075	138	
123265	43	
ST506	4493	
123900	976	

3517

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Training					·								
Unapproved			<u> </u>	L	l		AULT	CATE	SORY				
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j		Bending				Bend	П	rain			Ovalized	Γ	Pressure/Forced
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ļ		Cracks				Broken/Damaged	In	specti	on Incomplete		Part Incorred	t [Weld
		Crushed/	Crimped			Burrs	In	structi	ions Incomplete/U	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
į		Cuffs				Contamination	\square	1ainte	nance		Part Moved	_	
		Heat Trea	ət			Countersink	М	lislabe	led		Positioned W	Vrong _	
		Inspectio	n Strip in	Tube		Cut Too Short	М	lisread			Power Loss/:	Surge	Other
		Ripples in	n Bend			Drill Holes		ffset					
		Torque W	Vaves in E	Extrusio	n 🗌	Drawing		ut of C	Calibration				<u> </u>
		Turning S	equence	<u> </u>		Finish		ut of S	equence				
1		Wave/Tw	vist in Tul	be		Folio	⁻ o	utside	Dimensions				

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		(2)	

D4092-041 MAINTENANCE STEP ASSEMBLY

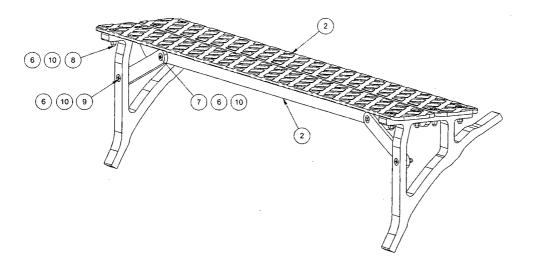
; ITEM PART NUMBER DESCRIPTION D4092-041 MAINTENANCE STEP ASSEMBLY D4092-1 MAINTENANCE STEP D4093-1 BRACKET D4093-3 BRACKET D4093-5 BRACE 12 MS21042L3 NUT MS24694-S54 SCREW MS24694-S55 SCREW MS24694-S56 2 SCREW NAS1149D0332J WASHER

> St. W. C ROT RATO ENGINE EDING UNCONTROLLED COPY SUBJECT TO A SEED ASSESSED. WITH HIS HIEF WORK ONDER 13-04-11

В	REDRAW	N; LOWERE	FOR AESTHETICS	RF	11.07 27
A	NEW ISS	UE		RF	10.09.16
REV.			DESCRIPTION	BY	DATE
DESIG	N	RF	DART AEROS	PACEUSA	INC
DRAW	N	RF		NT, WA	,
CHECK	(ED_	140	DRAWING NO.		REV. B
MFG. A	PPR.	91	D4092		SHEET 1 OF 6
APPRO	OVED	149	TITLE		SCALE
DE APP	PR.	#	MAINTENANCE	STEP ASS	Y NTS
DATE	11.0	7.27	COPYRIGHT © 2010 BY THIS COCUMENT IS PRIVATE AND CONFIDENTIAL A MOTTO SE USED FOR ANY PURPOSE OR COPED MICHIGHT PERMISSION OF MICHIGHT PERMISSION OF THE PER	ND IS SUPPLIED ON THE EXPRESS	CONDITION THAT IF IS

99513

ITEM	-042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2_	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

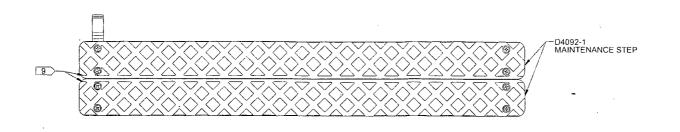


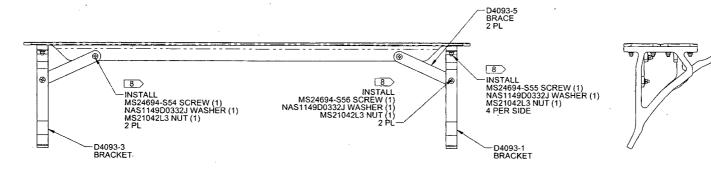
D4092-042 MAINTENANCE STEP ASSEMBLY



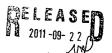
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MFG. APPR.	all	D4092 SHEET 2'OF
APPROVED	NP	TITLE SCALE
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D4092-041 MAINTENANCE STEP ASSEMBLY



D

NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 5.37 lbs
8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
9) GRIP CUTOUT TOWARD CENTER

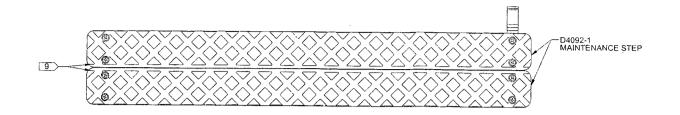
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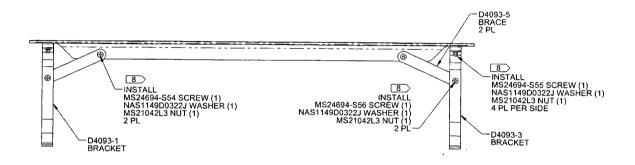
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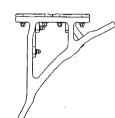
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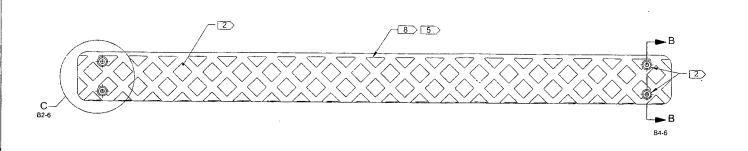


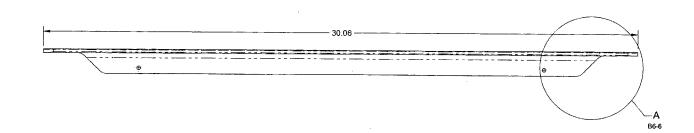
D4092-042 MAINTENANCE STEP ASSEMBLY

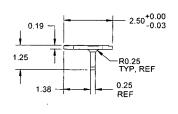
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NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: PER QSI 044 6.1
7) WEIGHT: 5.37 lbs
8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
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APPROVED	NA	TITLE	SCALE
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DATE 11.07.27		COPYRIGHT @ 2010 BY DART AEROSPACE USA, INC. THIS DOLLMER'S PRIVATE AND CONFORMINE, NAME OF SUPPLIED ON THE EXPRESS CONCIDENT THAT IT IS NOT TO BE USED FOR ANY ARROSS OF COORDING OR COMPANIZED TO ANY OTHER PRISON ARROST.	







D4092-1 MAINTENANCE STEP (MAKE FROM D2761 EXTRUSION)

5

2011 -09- 2 2

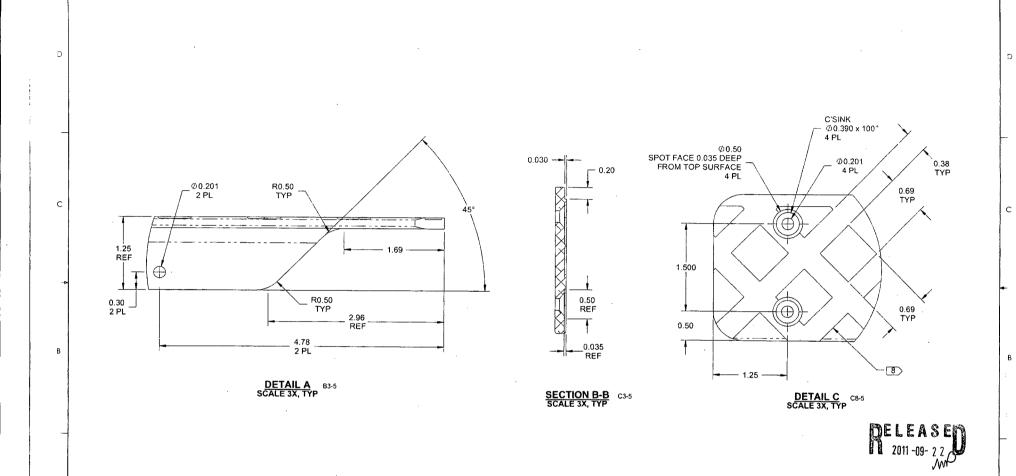
NOTES:
1) MATERIAL: MAKE FROM D2761 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
6) IDENTIFICATION: INA
7) WEIGHT: 1.97 lbs
8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45 * PATTERN 0.38 APART

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DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	14	DRAWING NO.	REV. B
MFG. APPR.	al	D4092 SHEE	T 5 OF 6
APPROVED	149	TITLE	SCALE
DE APPR.	#	MAINTENANCE STEP ASS'Y	NTS
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